DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-018750 Address: 333 Burma Road **Date Inspected:** 09-Oct-2010

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 700 **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes An Qing Xing No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No Yes N/A **Delayed / Cancelled:** No

Bridge No: 34-0006 **Component: OBG COMPONENT**

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Trial Assembly Yard

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG segment 11AE to 11BE, weld No.DP705-001-007. The welder is identified as #040320. ZPMC QC is identified as Mr.An Qing Xing. The welding variables recorded by QC appear to comply with WPS-B-T-4114-1.

SMAW in the 4F position for the OBG segment 11AE to 11BE, weld No.DP717-001-013. The welder is identified as #044504. ZPMC QC is identified as Mr.An Qing Xing .The welding variables recorded by QC appear to comply with WPS-B-T-4114-1.

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Suspender Bracket SB86E, UT repair weld No.SB20-086-037. The welder is identified as #062762. ABF QA is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-REPAIR. The weld repair report is identified as WR15676.

WELDING INSPECTION REPORT

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Bay#16

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG longitudinal Diaphragm lifting Lug, weld No.LD3034-001-194. The welder is identified as #040344. ABF QA is identified as Mr.Li Shi You .The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U5-F.

FCAW in the 2F position for the OBG Segment 13AW bottom plate to stiffener, weld No.BP3056-001-089/090. The welders are identified as #070254 and #037705. ZPMC QC is identified as Mr.Liu Dao Fang. The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U5-F.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between side Plate to side Plate for segment 10BE to 10CE at Cross Beam side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

OBE10C-001,002

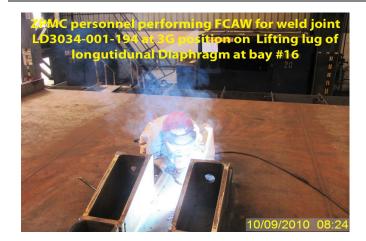
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer